

17-4 PM H900 #20

Work Order ID 163756***163756***

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Thursday, July 06, 2017 2:25:59 PM

Item ID: D4885-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting

Start Date: 7/6/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/1/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 06 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4885

REV A

105

2.93

105

Doosan

Memo

0.50

Doosan Lathe

-Machine blank as per Machinist's turning detail, folio+drawing D4885-3.

DAS
33
9-89

17/08/17

115

0.49

115

HAAS 5AXIS

Memo

0.98

HAAS CNC vertical machine #5

Mill as per folio FB547.

Dwg. rev: A

Folio rev: AA

D.O 17-09-23

DAS
08
9-89

Work Order ID 163756

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Item Name: End Fitting
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Required Date: 8/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
117 *117* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.04		B.a 17-09-24		4	Ø		DAS 08 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4	Ø		DAS 49 9-89 17/09/25
130 *130* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo ISSUE P/O : <u>37837</u> C OF C IS REQUIRED	0.00 288.00				4		SEP 2 6 2017	DAS 13 9-89

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Item ID: D4885-3 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 8/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.08							
Packaging									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.08							
Quality Control									
160	Identify as per dwg & Stock Location: 5126	0.00							
160									
Packaging	Memo	0.04							
Packaging	IDENTIFY AS PER QSI 044 6.1								

1X Sp 17-9-26

DAS 38 9-89

SEP 27 2017

DAS 6 9-89

SEP 27 2017

Work Order ID 163756

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Item ID: D4885-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Fitting
Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21 - Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.40							
Quality Control									

SEP 27 2017

DAS
21
9-89

Picklist Print

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Work Order ID: 163756

163756

Parent Item: D4885-3

D4885-3

Parent Item Name: End Fitting

Start Date: 7/6/2017

Required Date: 8/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R2.000		Purchased	No			105	f	27.6700	0.41	1.726316		DAS 33 9-89	
M174PH-H900R2 000									**				
17-4SS H900 ROUND BAR 2.000												17/08/06	

Location

Loc Qty

Loc Code

MAT031

27.67

M128314

11.21

M128809

12

M129892

4.46

1.3'

DART AEROSPACE LTD		Work Order: 163756
Description: END Fitting		Part Number: D4885-3
Inspection Dwg: D4885	Rev: A	Page 1 of 1

INSPECTION SHEET

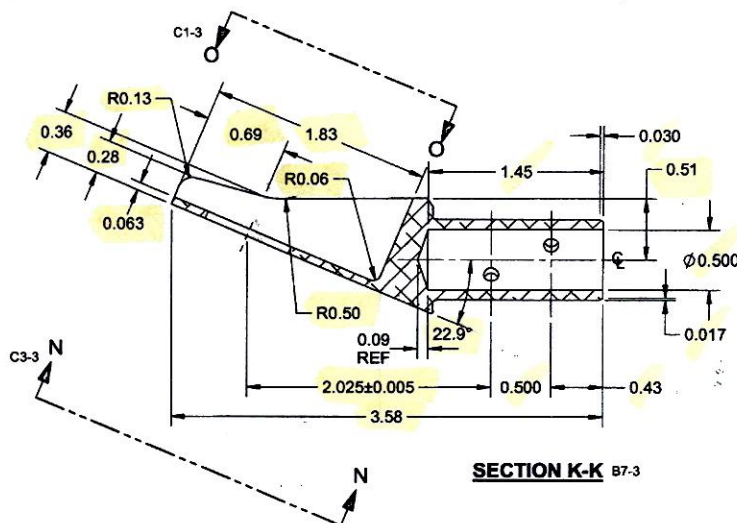
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ 0.670	+0.000 -0.001	0.6695	✓		MIP-01	Mic
1.41	+0.030	1.410	✓		MIP-04	Vern
φ 0.88	+0.030	0.890	✓			
R 0.031	+0.010	0.031	✓			
φ 0.125	+0.004 -0.001	0.126	✓			
30°	+0.5°	30°	✓			
φ 0.500	+0.004 -0.001	0.504	✓			
1.45	+0.030	1.420	✓			
0.017	+0.010	0.020	✓			
0.030	+0.010	0.040	✓			
0.43	+0.030	0.430	✓			
0.500	+0.010	0.500	✓			
3.58	+/-0.030	3.584	✓		H-6	31006
2.075	+/-0.005					
R0.50	+/-0.030	R0.500	✓		R-6	ref.
0.063	+/-0.010	0.064	✓		Mic	GA-03
0.28	+/-0.030	0.287	✓		H-6	31006
0.36	+/-0.030	0.367	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.69	+/-0.030	0.690	✓		H-6	31006
R0.06	+/-0.030	R0.063	✓		R-6	ref.
1.83	+/-0.030	1.8305	✓		H-6	31006
0.51	+/-0.030	0.5118	✓		"	"
0.68	+/-0.030	0.6815	✓		"	"
φ 0.750	+0.000/-0.001	0.7493	✓		T-6/Mic	ref. / GA-03
0.11	+/-0.030	0.128	✓		Vern	GA-13
0.073	+/-0.010	0.073	✓		Mic	GA-03
1.06	+/-0.030	1.064	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.

Measured by: DAS 33 9-89	Checked by: DAS 49 9-89	QC Inspector:
Date: 17/02/01	Date: 17/04/25	Date:

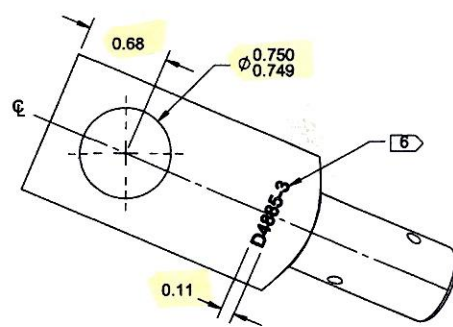
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

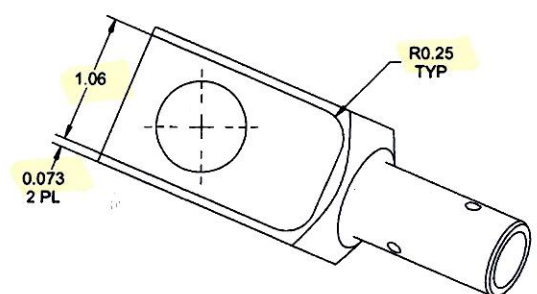
8 7 6 5 4 3 2 1



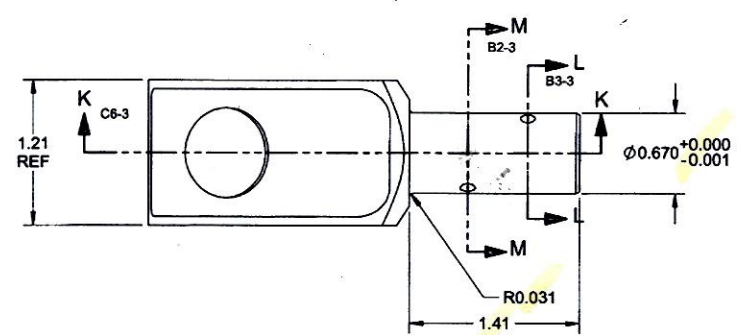
SECTION K-K B7-3



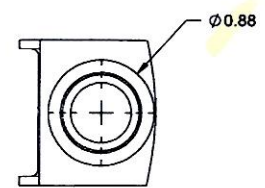
AUXILIARY VIEW N-N C8-3



AUXILIARY VIEW O-O D7-3



SECTION L-L B6-3



SECTION M-M B6-3

- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
 - 7) WEIGHT: 0.22 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

D4885-3 END FITTING
 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 103756 M/S 70706

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4885	REV. A
MFG. APPR.	JLM	TITLE END FITTING	SHEET 3 OF 5
APPROVED	HS	SCALE	NTS
DE APPR.	DS	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.12.01		

2013-12-12

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37837**

Purchase Order Date 9/22/2017

PO Print Date 9/26/2017

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Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71401-45	procurement quality clauses	9/26/2017 No 9/26/2017		1.00	\$0.00	\$0.00
Line Total:							\$0.00
2	163756	D4885-3 END FITTING	9/26/2017 Yes 9/26/2017		4.00	\$0.00	\$0.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417							
Line Total:							\$0.00
3	166321	D4884-1 END FITTING	9/26/2017 Yes 9/26/2017		4.00	\$0.00	\$0.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417							

Note:

9/26/2017

